

Date: Thursday, 13/11/2008 1:05:44 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PEDAL MOUNT ANGLE		
Job Number	: 43415		Part Number	: D32083		
Estimate Number	: 10780		Drawing Number	: D3208 REV A1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 13/11/2008 S.O. No. :		Drawing Revision	: A1		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 02/12/2008 Qty: 10 Um: Each		
Previous Run	: 37102					
Written By	:					
Checked & Approved By	: <u>Julie Dawson</u>					
Comment	: Est: B04.05.25 Material changed for Step 4KJ/JLM Est Rev:C Now on Waterjet 06-10-12 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6S063	6061-T6 .063 Sheet	
		Comment: Qty.: 0.0692 sf(s)/Unit Total : 0.6920 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Batch: <u>108279</u> FB 8-11-25	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3208 Dwg Rev: <u>A1</u> FB 8-11-25 Prog Rev: <u>A1</u>	
		2-Deburr if necessary FB 8-11-25	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr D3208-3 Form D3208-3 as per Dwg D3208	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 1:05:44 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL MOUNT ANGLE

Job Number: 43415

Part Number: D32083

Job Number:



Seq. #: Machine Or Operation:

Description :

Polish any marks on part within 01. of Dwg D3208

SB 08/12/10

(11)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/10

(11)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/11

(11)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

M-1 08/12/11

(11x)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST. 20d

AS 08/12/12 (XU)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/15 JJ

Job Completion



MF 08-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43415
Description: Pedal Mount Angle	Part Number:	D3208-3
Inspection Dwg: D3208 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BS	Audited by:		Prototype Approval:	N/A
Date:	8-1-25	Date:	08/01/25	Date:	N/A

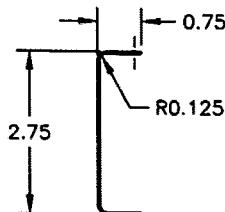
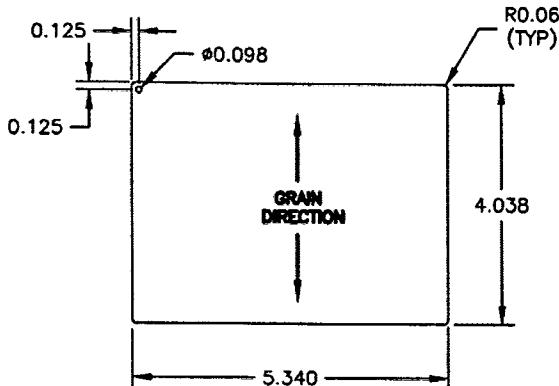
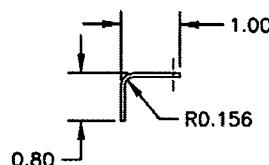
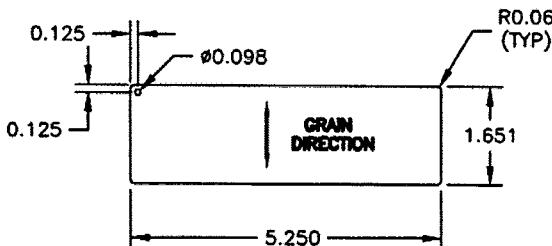
Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	SJL

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

RELEASED
04.04.05

A	04.01.27	NEW ISSUE
AI	<i>[initials]</i> 04.05.25	(CHANGE DIM; NOTE 3) CHANGE


**D3208-1 DOUBLER
BEND DETAIL**
**2 D3208-1 DOUBLER
FLAT PATTERN**

**D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL**
**3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN**
NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

[initials]

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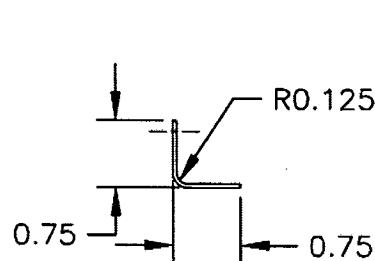
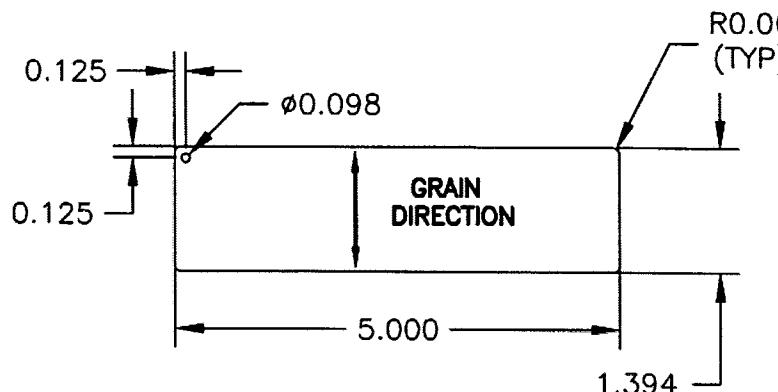
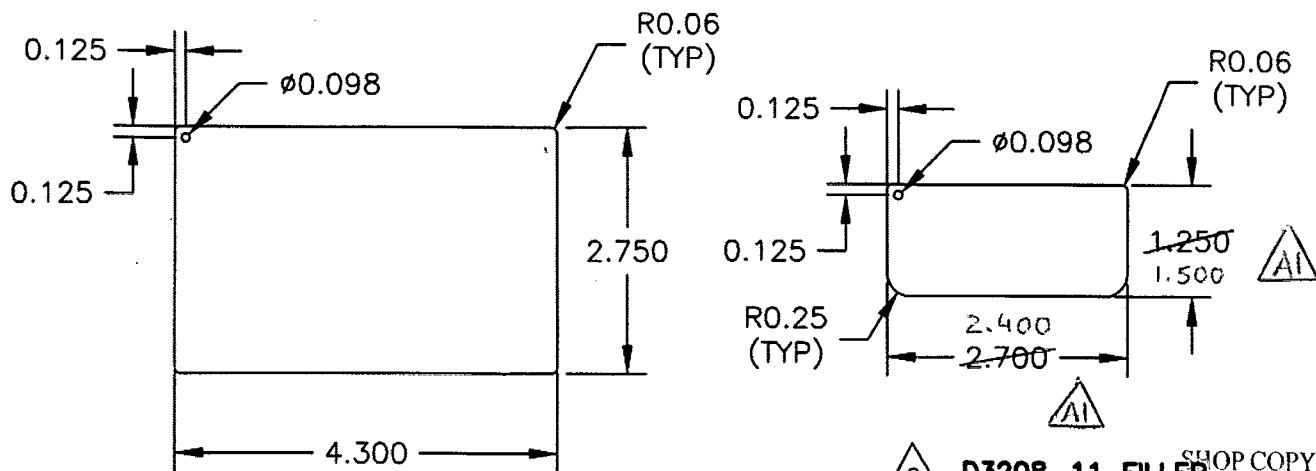
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WORK ORDER

 NO. 43415

DART

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED04.04.05 *[initials]***D3208-5 MOUNT ANGLE
BEND DETAIL****D3208-5 MOUNT ANGLE
FLAT PATTERN****D3208-11 FILLER**

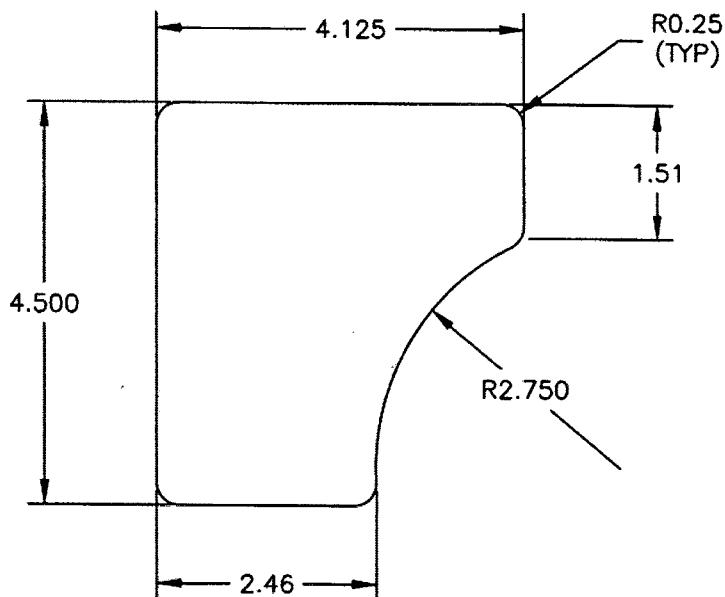
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NO. 43415

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DATE 04.01.27	TITLE DOUBLER	SCALE 1:2

RELEASED
04.04.05 C**D3208-9 DOUBLER**

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